

CLAIM AMENDMENTS

1 1. (original) A method of making bags, comprising the
2 steps of:

3 (a) providing along a transport path a welding station
4 having at least two spaced-apart elongated separation-welding
5 elements extending at a right angle to said path and adapted to
6 simultaneously seam and ~~to~~ separate a bag from said web between
7 said separation-welding elements;

8 (b) advancing a double-layer synthetic resin film web and
9 bags separated therefrom stepwise forwardly through said transport
10 path on a first suction belt conveyor which is continuous at least
11 over a length of said first suction belt conveyor encompassing all
12 of said separation-welding elements at a certain stepping frequency
13 and synchronously actuating said separation-welding elements in
14 step with advance of said first suction belt conveyor to seam and
15 separate individual bags from said web and advance said web and
16 said bags on said first suction belt conveyor;

17 (c) controlling a step length of each advance of said
18 suction belt conveyor so that said step length is equal to a
19 product ($n \times w$) of the number (n) of said separation-welding
20 elements and the width (w) of said bags;

21 (d) picking up said bags from said first suction belt
22 conveyor at a location downstream of said welding station with a

23 second suction belt conveyor disposed above said first suction belt
24 conveyor; and

25 (e) advancing said second suction belt conveyor synchro-
26 nously with stepping frequency of the first suction belt conveyor,
27 said second suction belt conveyor being advanced with a stroke
28 length per advance which corresponds to that of said first suction
29 belt conveyor or is slightly greater than the stroke length of said
30 first suction belt conveyor, said bags being collected from said
31 second suction belt conveyor on pins of a collecting device having
32 an endless belt extending partly beneath a region of said second
33 suction belt conveyor, said bags being pressed onto said pins
34 mechanically, by skids from above padding said bags in stacks on
35 said pins to form respective pads of said bags, and transferring
36 said pads by a robot from said collecting device to packing car-
37 tons.

2 - 7 (canceled)

1 8. (currently amended) The method defined in claim 1
2 wherein two of said bags are simultaneously seamed and separated in
3 said welding station by two of said separation-welding elements.

1 9. (currently amended) An apparatus for making bags
2 from a synthetic resin film in the form of a double layer web, said
3 apparatus comprising a first suction belt conveyor receiving said
4 web and transporting said web along a transport path;

5 a welding station along said path having at least two
6 spaced-apart elongated separation-welding elements extending at a
7 right angle to said path and adapted simultaneously to seam and to
8 separate the bag from said web between said separation welding
9 elements, said separation welding elements extending at a right
10 angle to said path;

11 a second suction belt conveyor downstream of said welding
12 station and disposed above said first suction belt conveyor for
13 picking up said bags from said first suction belt conveyor; and

14 drives for said first and second suction belt conveyors
15 for stepping said bags and said web along said first suction belt
16 conveyor and said bags with said second suction belt conveyor
17 synchronously with the stepping of said first suction belt con-
18 veyor, said first suction belt conveyor extending without interrup-
19 tion over an entire region encompassing the separation welding
20 element of said welding station, said welding station being pro-
21 vided with two of said separation welding elements said first
22 suction belt conveyor extending beneath said second suction belt
23 conveyor; a pin-stacking device downstream of said welding station
24 and receiving said bags from said second suction belt conveyor,
25 said pin-stacking device comprises a belt provided with pins for
26 receiving stacks of said bags and advancing said stacks of bags;
27 and a knock-off device at an end of said second suction belt
28 conveyor for pressing said bags downwardly onto pins of said pin-
29 stacking device.

10 - 14 (canceled)

1 15. (currently amended) The apparatus defined in claim
2 ~~14~~ 9 wherein said second suction belt conveyor comprising a plural-
3 ity of parallel belts and said knock-off device comprises verti-
4 cally movable pressing pads disposed between parallel belts of said
5 second suction belt conveyor.

1 16. (original) The apparatus defined in claim 15
2 wherein said first suction belt conveyor is a single belt extending
3 at least a full width of said web.